

Date: Monday, 19/01/2009 2:06:26 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HANDLE WELDMENT
Job Number :	44898		
Estimate Number :	12035		
P.O. Number :		Part Number :	D33551
This Issue :	19/01/2009	Drawing Number :	D3355 REV. B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	/ /	Drawing Revision :	B
Previous Run :	44250	Material :	
Written By :		Due Date :	30/01/2009
Checked & Approved By :	JUD 09.01.20	Qty:	10
Comment :	est rev A 06.01.19 new issue EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M4130NR1250	4130N ROUND BAR 1.250
-----	-------------	-----------------------



Comment: Qty.: 0.5250 f(s)/Unit Total: 5.2500 f(s)
 AISI 4130N ROUND BAR 1.250"dia. batch: M110746

09/02/07

10 PCS

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut blank 6.10" long

09/02/07

10 PCS

3.0	LATHE CONV.	CONVENTIONAL LATHE
-----	-------------	--------------------



Comment: CONVENTIONAL LATHE
 1-Turn as per Dwg D3355

09/02/07

10 PCS

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------



Comment: CONVENTIONAL MILLING MACHINE
 1- Mill as per dwg D3355

2-Deburr as per dwg D3355

09/02/09

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

09/02/09 (410)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 19/01/2009 2:06:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 44898

Part Number: D33551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Carl

JS 09/02/09 X10

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/11 JS

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

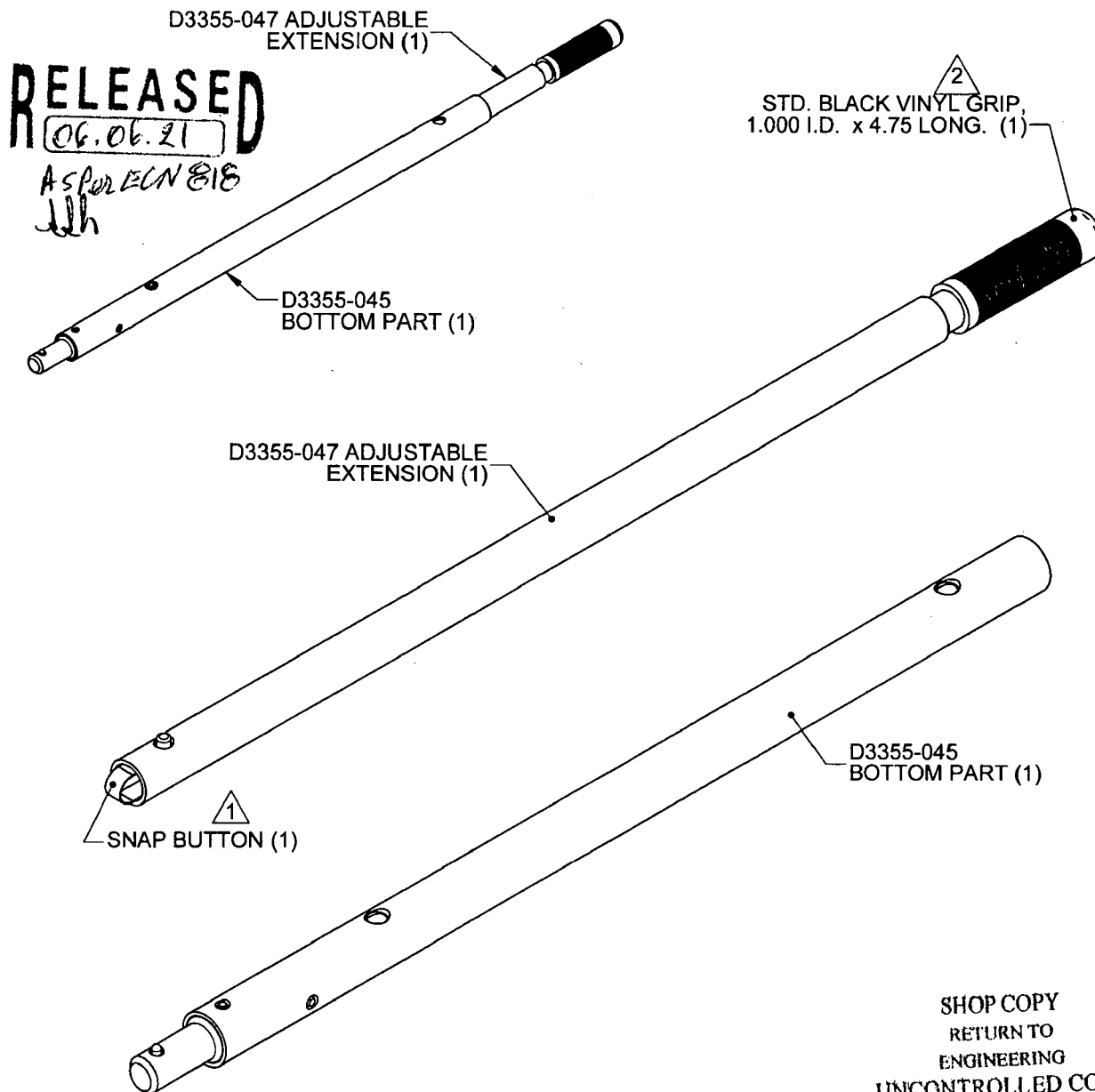
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:8
A	05.02.07	NEW ISSUE	
B	06.05.31	EDITED NOTE 1 (SHEET 2), UPDATE DETAIL B	



D3355-041 HANDLE ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-2160
- 2) POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N GP-1R

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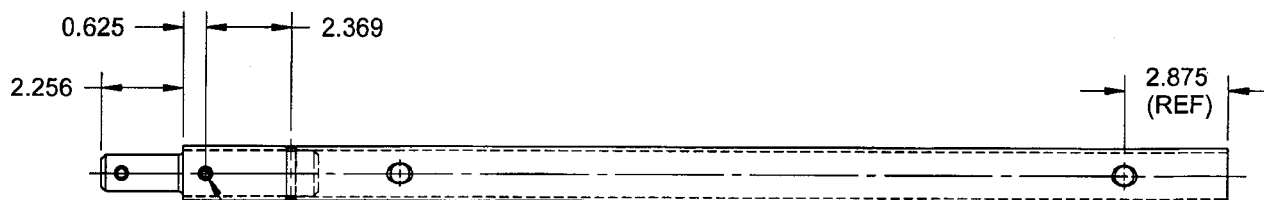
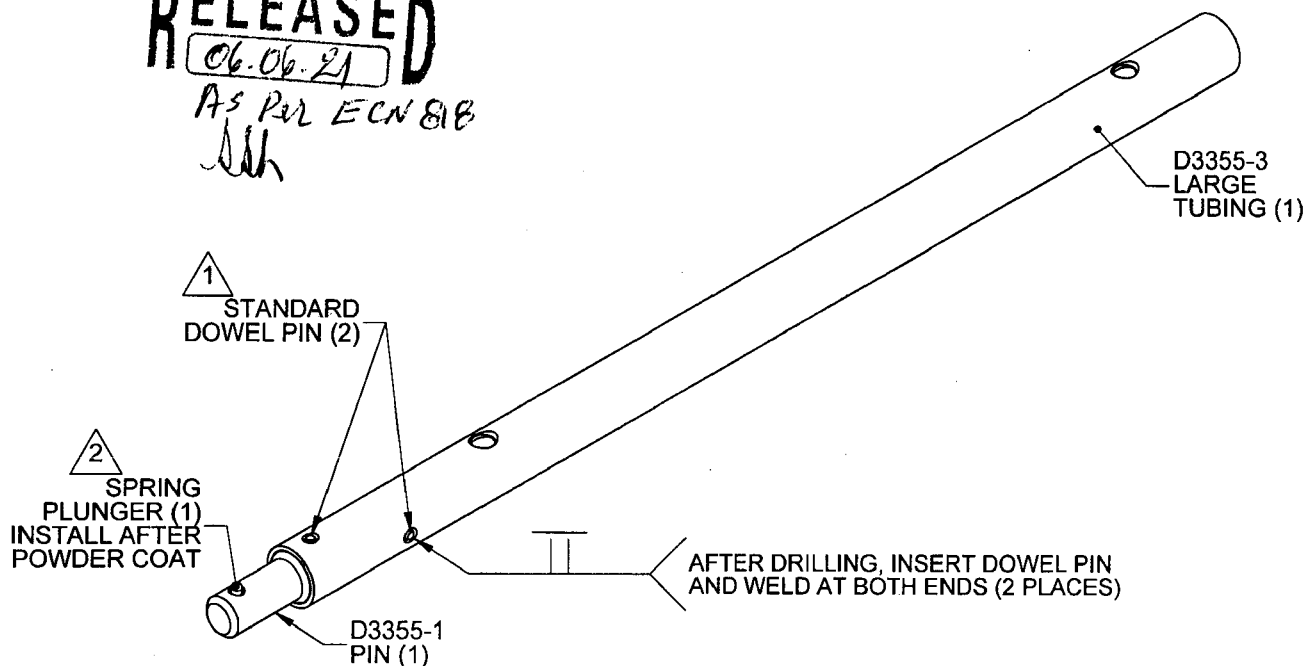


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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06-06-21

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DRILL 90° FROM EACH HOLES
Ø 0.250 (DRILL THRU (2 PLACES) AND
CHAMFER 0.06 x 45° (4 PLACES))

D3355-045 BOTTOM PART

NOTES:

- 1) STEEL STANDARD GROUND DOWEL PIN, Ø 0.250 X 1.50 LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY COO P/N VA 7730
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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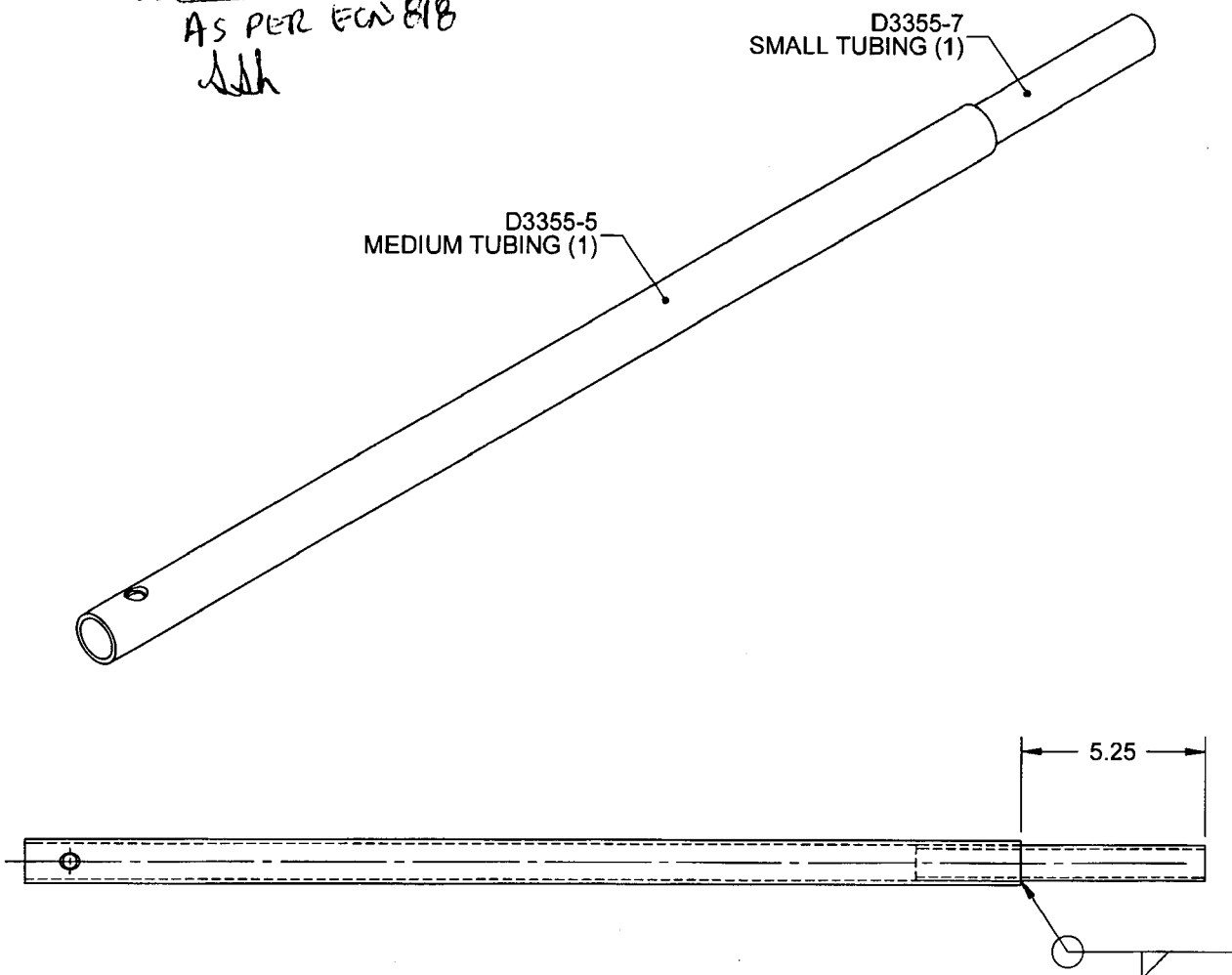


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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

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ASH



D3355-047 ADJUSTABLE EXTENSION

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

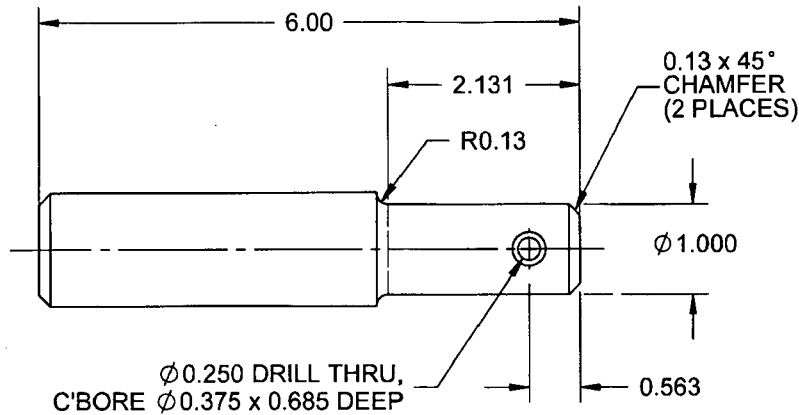
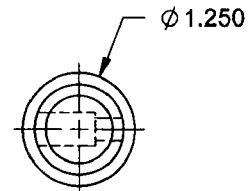
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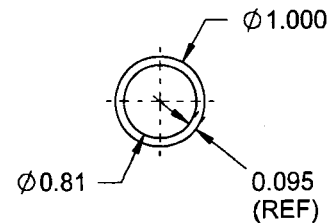
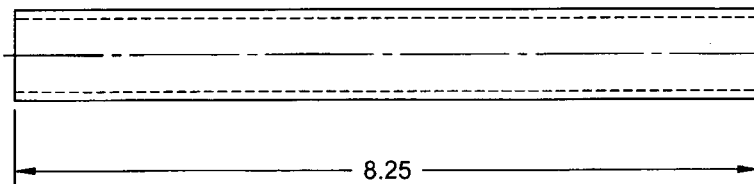
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DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:2

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06.06.21
AS PER ECN 818**D3355-1 PIN****D3355-1 NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

**D3355-7 SMALL TUBING****D3355-7 NOTES:**

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.000W.095)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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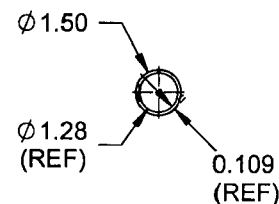
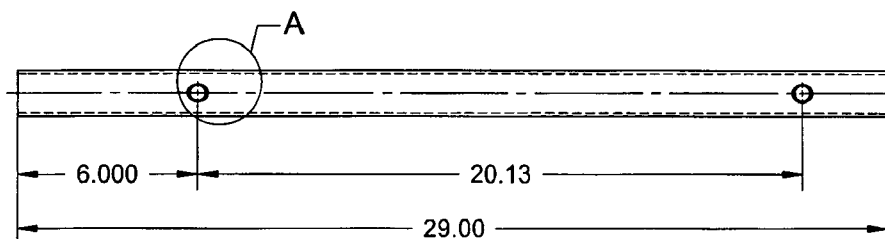


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DATE 06.05.31		TITLE HANDLE WELDMENT	SCALE 1:6

CHAMFER $\phi 0.687$ (11/16)
x 45°, 0.060 DEEP
(2 PLACES)

$\phi 0.531$ (17/32) DRILL
THRU (2 PLACES)

DETAIL A
SCALE 1 : 2



D3355-3 LARGE TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING (REF. DART SPEC. M1020TR1.500W.109)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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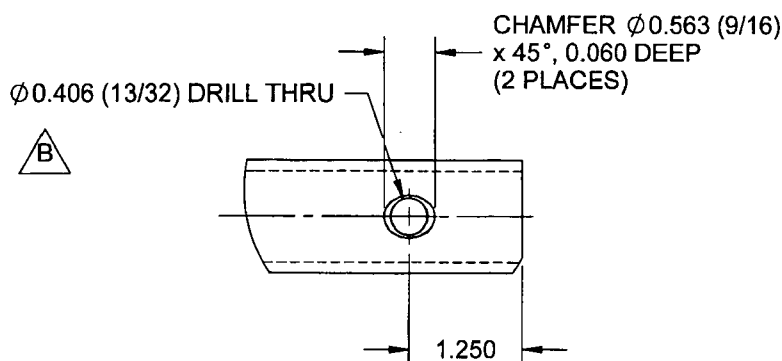
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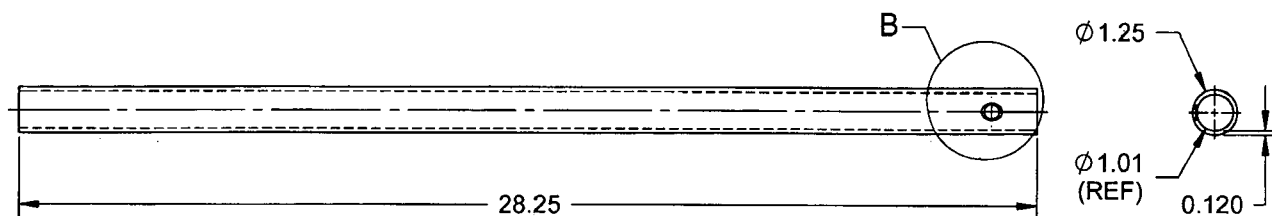


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DETAIL B
SCALE 1 : 2



D3355-5 MEDIUM TUBING

NOTES:

- 1) MATERIAL: AISI 1018-1025 MILD STEEL SEAMLESS ROUND TUBING
(REF. DART SPEC. M1018TR1.250W.120)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.015 TO 0.030

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